

Date: Tuesday, 12/08/2008 1:01:13 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET, GAS SPRING
Job Number	: 41174		
Estimate Number	: 10179		
P.O. Number	:	Part Number	: D2144
This Issue	: 12/08/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2144 REV. D
First Issue	: / /	Project Number	: N/A
Previous Run	: 34465	Drawing Revision	: D
Written By	:	Material	:
Checked & Approved By	: <u>51008.8.12</u>	Due Date	: 08/09/2008
Comment	: Est: D 04.05.06 Reformat KJ/RF	Qty:	40
	Est Rev:E Now on Waterjet 06-10-15 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.0945 sf(s)/Unit Total : 3.7800 sf(s)
 304/316 .063 Sheet 16GA
 Batch: 108724 HB 8-8-21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2144
 Dwg Rev: D
 Prog Rev: D

HB 8-8-21

2-Deburr if necessary. HB 8-8-21

44

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-8-21

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

508108121 coater 244

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

n/m Done at step #22
508108121

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/08/2008 1:01:13 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET, GAS SPRING

Job Number: 41174

Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2144

Rev: D

Sp 08/11/04

(44)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
Sp 08/11/04

(44)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FAB RESOURCE 1

1- Weld corner as per Dwg D2144 & QSI 004

2- Grind flush

Pl 08.11.25

(44)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Sp 08/11/26

(44)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
Sp 08/11/26

(44)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:50
220 °F
9:20

M-F 08/11/27

(44X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-11-27

(44)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 198A

8/11/27

Sp
50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/08/2008 1:01:13 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET, GAS SPRING

Job Number: 41174

Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/28 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-11-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41174
Description: Hinge Bracket		Part Number: D2144
Inspection Dwg: D2144 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.380	*			
3.022	+/-0.010	3.020	*			
2.468	+/-0.010	2.469	*			
1.913	+/-0.010	1.913	*			
1.555	+/-0.010	1.561	*			
4.126	+/-0.010	4.126	*			
3.465	+/-0.010	3.469	*			
0.340	+/-0.010	.341	*			
0.625	+/-0.010	.627	*			
1.000	+/-0.010	1.000	*			
1.083	+/-0.010	1.083	*			
1.660	+/-0.010	1.660	*			
2.312	+/-0.010	2.313	*			
2.844	+/-0.010	2.844	*			
3.294	+/-0.010	3.287	*			
Ø0.257	+0.006/-0.001	.260	*			
Ø0.171	+0.005/-0.001	.173	*			
Ø0.320	+0.006/-0.001	.322	*			
0.354	+/-0.010	.352	*			
0.063	+/-0.010	.061	*			

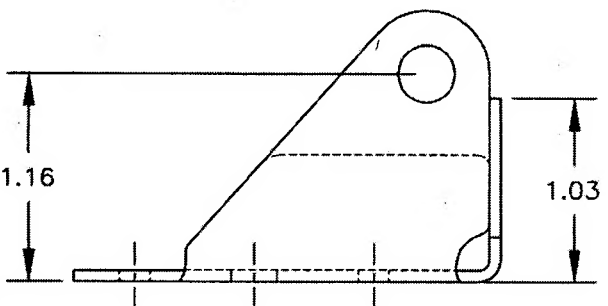
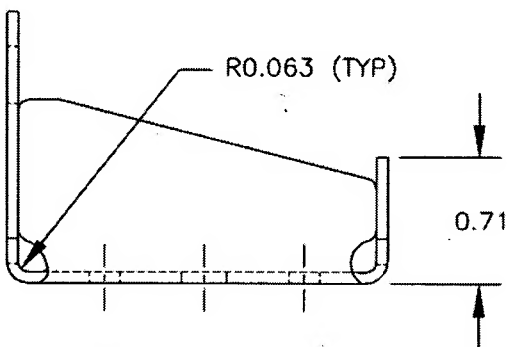
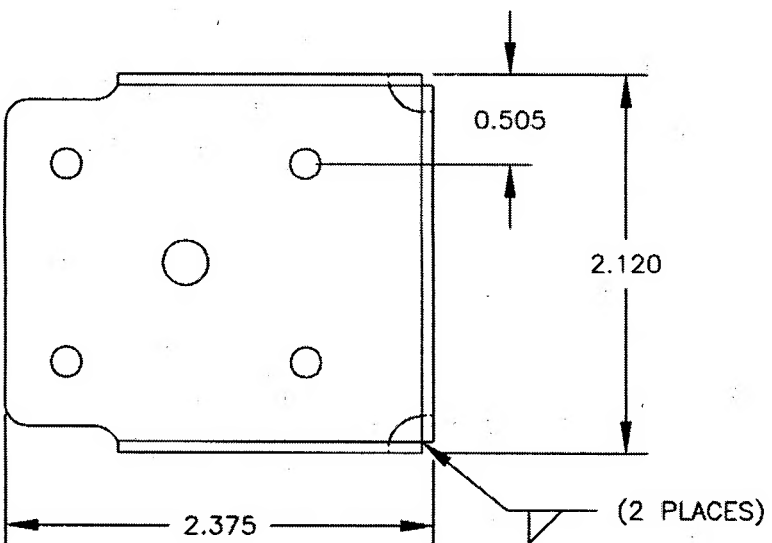
Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 8-8-21	Date: 08/08/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	



RELEASED
98.10.15 KE

DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		KE		HAMKESBURY, ONTARIO, CANADA	
CHECKED	MA	APPROVED	KE	DRAWING NO.	REV. D
DATE	98.10.08	TITLE	HINGE BRACKET	D2144	SHEET 1 OF 2
			SCALE	1:1	
A	95.03.17	NEW ISSUE			
C	96.06.05	FLAT PATTERN LAYOUT ADDED			
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)			

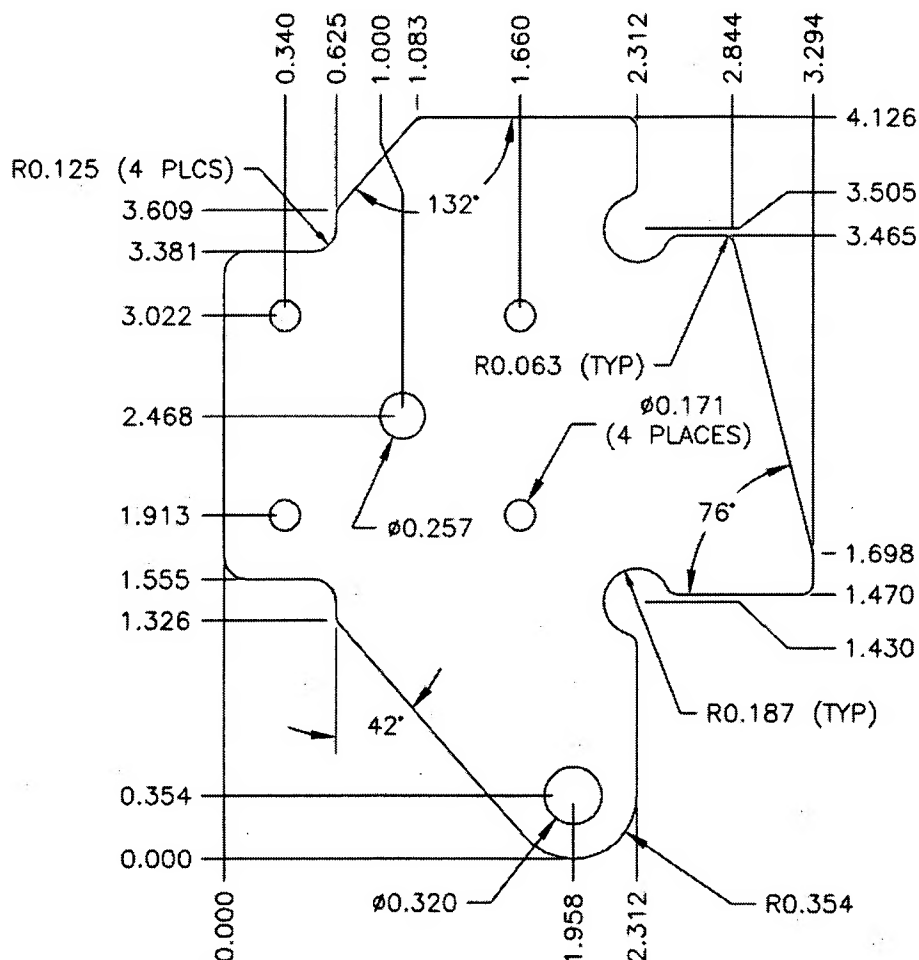


FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED M	APPROVED Q	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08		TITLE HINGE BRACKET	SCALE 1:1

RELEASED
98.10.15 KE



D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NOTED 4/11/74